

Date: Wednesday, 4/4/2007 9:03:37 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	LUG
Job Number	31609B		
Estimate Number	10841		
P.O. Number	N/A	Part Number	D22493
This Issue	4/4/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2249 REV. E
First Issue	N/A	Project Number	N/A
Previous Run	31485B	Drawing Revision	E
Written By		Material	N/A
Checked & Approved By	<u>9/07/04,04</u>	Due Date	4/11/2007
Comment	Qty: 10 Um: Each Est: D 05/02/04 Added Step 9 KJ/RF Est Rev:E Now On Waterjet 07-03-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
	Comment: Qty.: 0.1470 sf(s)/Unit Total : 1.4700 sf(s) 304/316 .063 Sheet Batch: H103961	SAD 07/04/14
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D2249 Dwg Rev: <u>E</u> Prog Rev: <u>B</u>	<u>DM</u> 07/04/00 SAD 07/04/14
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAD 07/04/14
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<u>MS</u> 07/04/15
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per Dwg D2249	<u>FC</u> 07/04/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:03:37 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31609B

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/04/24 (10)

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____ ST 21

107/04/25 (10)

8.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107/04/25 (10)

Job Completion



107/04/25 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31609 B
Description: Base Plate	Part Number:	D2249-3
Inspection Dwg: D2249 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

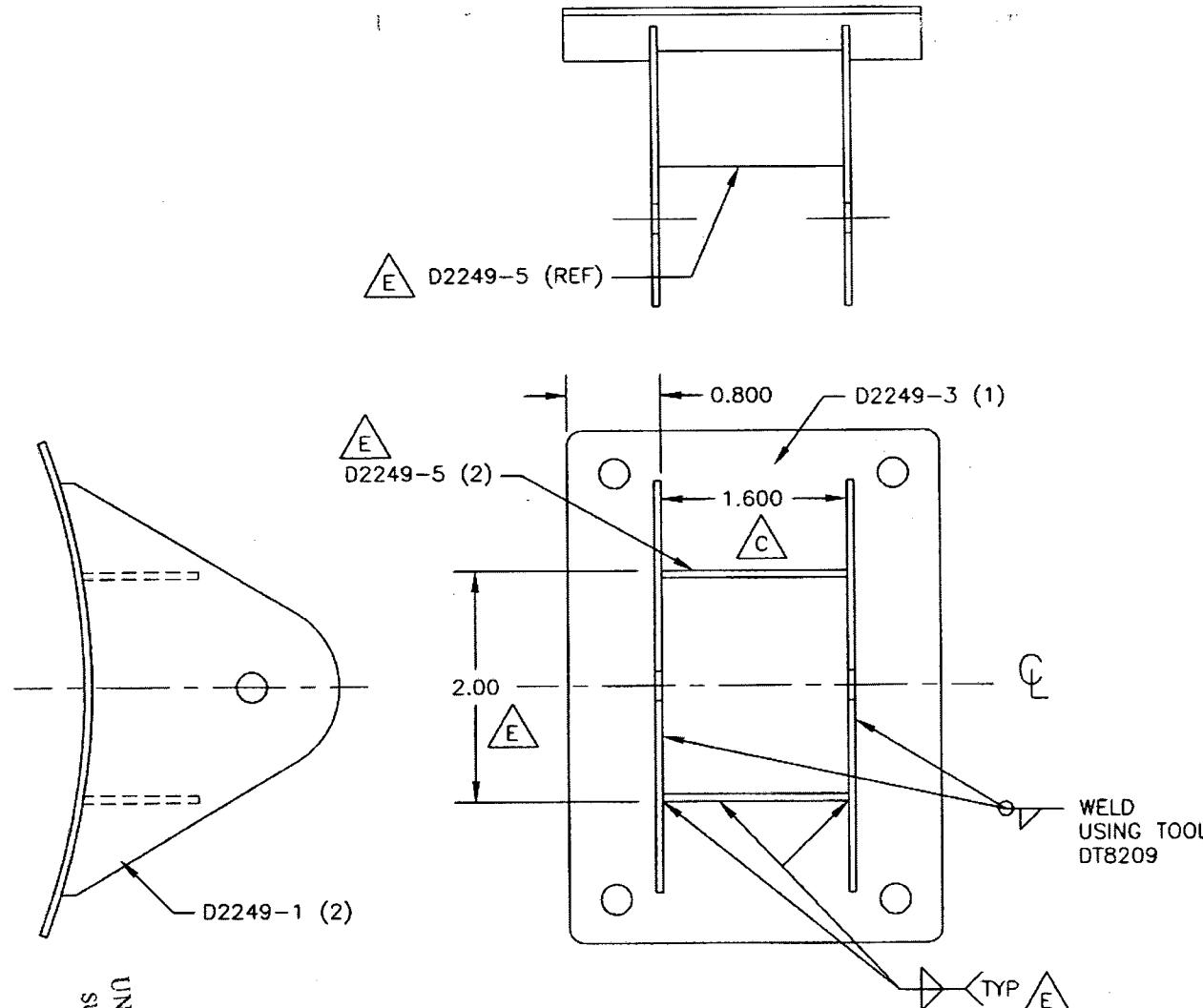
X First Article Prototype

Measured by:	SAN	Audited by:	MS	Prototype Approval:	N/A
Date:	07/04/14	Date:	07/04/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.23	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART**RELEASED**99.10.12
KCE

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED <i>KE</i>	APPROVED <i>M</i>	DRAWING NO. D2249	SHEET 1 OF 4
DATE 99.09.20	TITLE FITTING		SCALE NTS
A 94.06.20	NEW ISSUE		
B 95.11.30	DIMENSION CHANGE		
C 95.12.14			
D 98.04.30	ϕ 0.261 WAS ϕ 0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS		
E 99.09.20	ADDED GUSSET		

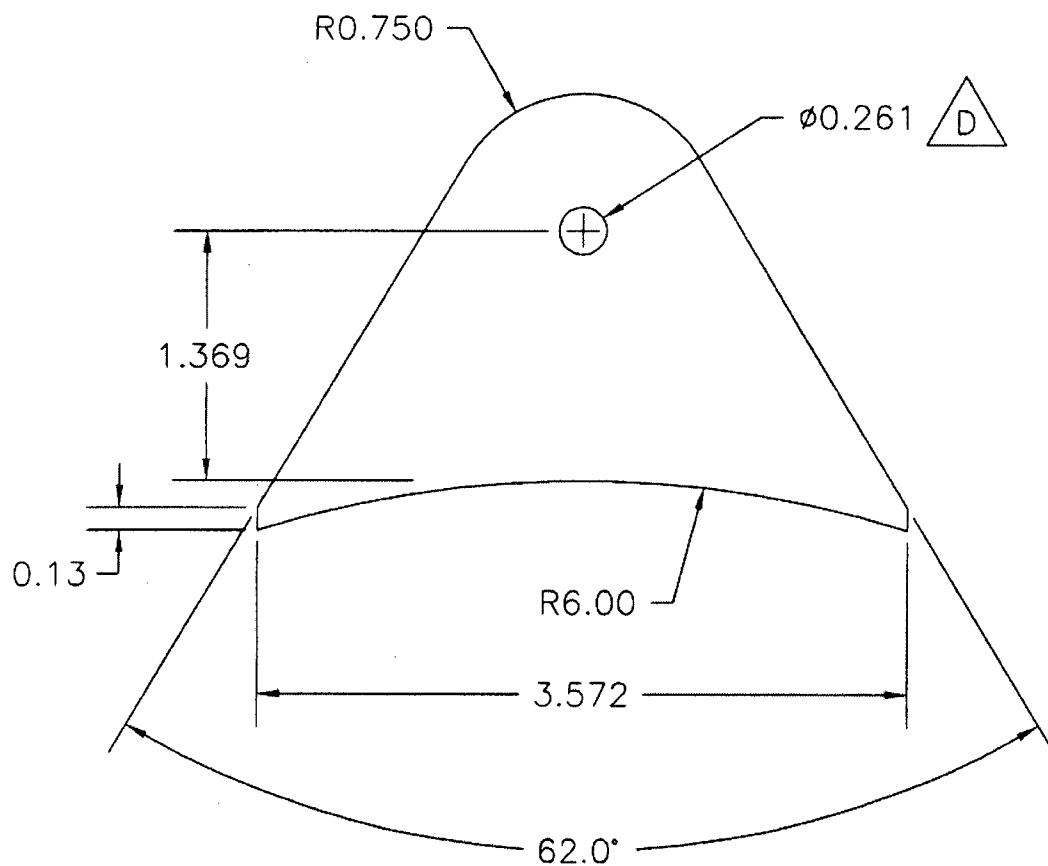
D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *31609-B*

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249
DATE 99.09.20	TITLE FITTING	REV. E SHEET 2 OF 4 SCALE 1:1

RELEASED
99.10.12 KED2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. *31609B*

DART

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CHECKED <i>KE</i>	APPROVED <i>M</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
(99.10.12 KE)

Φ0.261 (TYP) D R0.125 (TYP)

4.44



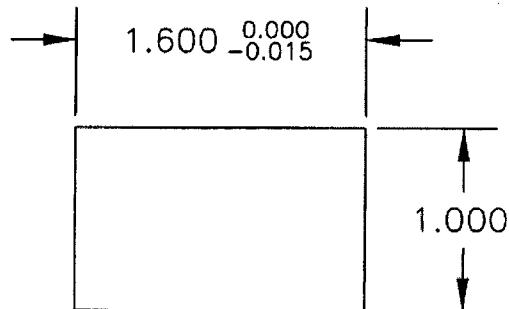
R6.0

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>MM</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED

49 10.12 KE

D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE

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WITHOUT NOTICE
WORK ORDER
NO. 31609B